

Date: Tuesday, 5/23/2006 8:35:35 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID
Job Number	: 27203		
Estimate Number	: 10549		
P.O. Number	: N/A	Part Number	: D206642311
This Issue	: 5/23/2006 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 27202	Material	: N/A
Written By	: <i>See Comment Below</i>	Due Date	: 6/18/2006 Qty: 1 Um: Each
Checked & Approved By	: <i>206-05-23</i>		
Comment	: Est Rev: 105.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC		

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-311 CHG004

KJ 06.06.06 (6)

2.0	27203A	206 L HIGH GEAR SKIDTUBE
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Comment: Sub-Component 206L/407 LOW, 407 HIGH GEAR SKIDTUBE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D2652	Bushing
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BUSHING

Pick:

Qty	Part Number	Description	Batch
24	D2652	Bushing	B25835 ✓
1	D206-642-341(REF)		B27203A

5.0	D2655	Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

TOW RING

Pick:

Qty	Part Number	Description	Batch
1	D2655	Tow Ring	B25145 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2659

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LUG ASSEMBLY

Pick:

Qty Part Number Description Batch

2 D2659 Lug Assembly

Batch
B26786 ✓

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

SET SCREW

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

Batch
B16400 ✓

8.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch

1 D2932-1 Saddle

Batch
B27147 ✓

9.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch

1 D2933-1 Saddle

Batch
B27206 ✓

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty Part Number Description Batch

2 D2934 Saddle Spacer

Batch
B25378 ✓

W/O:		WORK ORDER CHANGES					
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Job Number: 27203

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SADDLE SPACER

Pick:

Qty	Part Number	Description	Batch
2	D2935	Saddle Spacer	B25379 ✓

12.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SADDLE

Pick:

Qty	Part Number	Description	Batch
1	D2938-1	Saddle	148 B25379 ✓

13.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SADDLE

Pick:

Qty	Part Number	Description	Batch
1	D2939-1	Saddle	638 B25379 ✓

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
TOW RING

Pick:

Qty	Part Number	Description	Batch
1	D2968-043	Tow Ring	B24418 ✓

15.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT

Pick:

Qty	Part Number	Description	Batch
4	AN3-37A	Bolt	M13719 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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Job Number: 27203

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
8	AN3-41A	Bolt	M101369 ✓

17.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
1	AN4-5A	Bolt	M100857 ✓

18.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
12	AN4-6A	Bolt	M100478 ✓

19.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
4	AN5-10A	Bolt	M16941 ✓

20.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
8	AN5-11A	Bolt	M18918 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 27203

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

4 AN5-12A

Bolt

M15204 ✓

22.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

WASHER

Pick:

Qty Part Number

Description

Batch

12 AN960JD10

Washer

M100793 ✓

23.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Pick:

Qty Part Number

Description

Batch

1 AN960JD1016

Washer

M5519 ✓

24.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

WASHER

Pick:

Qty Part Number

Description

Batch

25 AN960JD416

Washer

M101369 ✓

25.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty Part Number

Description

Batch

8 AN960JD516

Washer

M101369 ✓

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 27203

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Pick:

Qty Part Number

1 AN970-4

Description

Washer

Batch

M100151 ✓

27.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

NUT

Pick:

Qty Part Number

12 MS21042L3

Description

Nut

Batch

M100094 ✓

28.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

NUT

Pick:

Qty Part Number

13 MS21042L4

Description

Nut

Batch

M19085 ✓

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-311

Location:

PPP Rev: D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/08/02

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:35:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 27203

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

17 08/08/02 ①

Job Completion



C206108102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 24/10/2006 8:31:20 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-642-311
Job Number	: 29118	Part Number	: Z_CUSTOM
Estimate Number	: 10804	Drawing Number	: REMOVE TOW RING
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 24/10/2006 S.O. No. : N/A	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : OVERHEAD	Due Date	: 24/10/2006
Previous Run	: 00015	Qty:	2 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
		<p>Comment: PACKAGING RESOURCE #1 REMOVE FROM STK 2 X D206-642-311 B <u>27202</u> / B <u>27203</u> <i>u 06.0.24</i> REMOVE TOW RING (TO BE USED IN D058-672 SKIDS, THAT MUST SHIP TODAY) D2968-043 B <u>B24418</u> <i>Rec'd 10/27 (2)</i> <i>3097 or 2291896 ✓</i></p>
2.0	PACKAGING 1	PACKAGING RESOURCE #1
		<p>Comment: PACKAGING RESOURCE #1 WHEN AVAILABLE, ADD 1 X TOW RING BACK TO EACH KIT D2968-043 B <u>28268</u> <i>06/10/27 (2)</i></p>
3.0	D2968043	Tow Ring
		<p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Tow Ring <u>B28268</u> <i>06/10/27 (2)</i></p>
4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
		<p>Comment: INSPECT 100% KITS FOR COMPLETENESS <i>06/10/27 (2)</i></p>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		<p>Comment: PACKAGING RESOURCE #1 REPACKAGE PER PPP <i>06/10/27 (2)</i></p>